

# Work Order ID 62057

Wednesday, September 15, 2010 1:48:35 PM



Page 1

Item ID: D2932-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 9/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*10-9-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2932	Rev C								
100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per								
110		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	<b>Memo</b>	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120		0.00							
	QC1- Inspect dimensions to dimension sheet								
QC	<b>Memo</b>	0.00							
Quality Control									

*B.A 10/11/09*

*6*

*0*

*B.A 10/11/09*

*6*

*0*

*B.A 10/11/09*

*6*

*0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/00	1001				10/1/00			

**NOTE:** Date & initial all entries

# Work Order ID 62057

Wednesday, September 15, 2010 1:48:35 PM

Page 2

Item ID: D2932-1

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Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 9/15/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	2L	10/11/11		6			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	2JH	10/11/11		6	0		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115291 Memo START TIME: 8:30 FINISH TIME: 9:00	0.00 0.00				6		10-11-12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62057**

Wednesday, September 15, 2010 1:48:35 PM

Page 3

Item ID: D2932-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 9/15/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 11 12 (6)

170

Identify as per dwg &amp; Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

10/11/12 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15

10-11-12 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 15, 2010 1:48:39 PM

Page 1

Work Order ID: 62057



Parent Item: D2932-1



Parent Item Name: Saddle LH Out, 206

Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B000.06.26 New DWG rev, (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	43.0000	1	6			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT042

43

59196

3

61250

40

6.0

H.A 10/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 62057
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.112	0.114	0.112	0.112	Mic	118-120
B	0.100	0.140		0.113	0.113	0.114	0.113	"	"
C	0.100	0.140		0.121	0.122	0.121	0.121	"	"
D	0.210	0.230		0.223	0.223	0.223	0.223	Vein	GA-01
E	1.245	1.255		1.250	1.250	1.250	1.250	"	"
F	1.245	1.255		1.250	1.250	1.250	1.250	"	"
G	2.495	2.505		2.500	2.500	2.500	2.500	"	"
H	0.510	0.515		0.510	0.510	0.510	0.510	"	"
I	1.572	1.582		1.577	1.577	1.577	1.577	"	"
J	2.495	2.505		2.500	2.500	2.500	2.500	"	"
K	0.257	0.262		0.258	0.259	0.259	0.259	"	"
L	0.312	0.317		0.315	0.315	0.315	0.315	"	"
M	0.235	0.240		0.237	0.237	0.237	0.237	"	"
N	0.100	0.140		0.115	0.115	0.115	0.115	Mic	GA-03
O	0.540	0.560		0.550	0.550	0.550	0.550	Vein	GA-01
P	0.490	0.510		0.498	0.499	0.500	0.502	"	"
Q	3.715	3.725		3.720	3.720	3.720	3.720	"	"
R	2.470	2.510		2.492	2.492	2.492	2.492	"	"
S	0.240	0.270		0.251	0.251	0.251	0.251	"	"
T	0.100	0.180		0.130	0.130	0.130	0.130	"	"
U	1.625	1.635		1.630	1.630	1.630	1.630	"	"
V	1.362	1.372		1.367	1.367	1.367	1.367	"	"
W	0.316	0.321		0.317	0.317	0.317	0.317	"	"
X	1.125	1.145		1.136	1.1366	1.1369	1.1354	Dial	HAAS2
Y	1.565	1.585		1.573	1.5738	1.5735	1.5724	"	"
Z	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: AA
Date: 10/11/09

Audited by: JL
Date: 10/11/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 62057
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		0.112	0.112				
B	0.100	0.140		0.114	0.113				
C	0.100	0.140		0.121	0.122				
D	0.210	0.230		0.223	0.223				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.259	0.259				
L	0.312	0.317		0.315	0.315				
M	0.235	0.240		0.237	0.237				
N	0.100	0.140		0.115	0.115				
O	0.540	0.560		0.550	0.550				
P	0.490	0.510		0.502	0.503				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		0.251	0.251				
T	0.100	0.180		0.130	0.130				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.317	0.312				
X	1.125	1.145		1.1362	1.1345				
Y	1.565	1.585		1.5727	1.5741				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: H.A
Date: 10/11/09

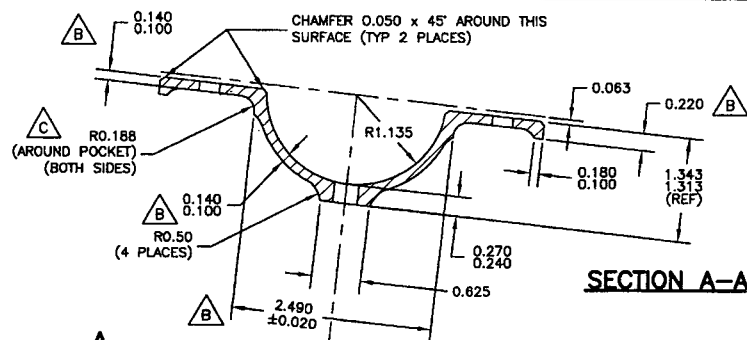
Audited by: SL
Date: 10/11/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

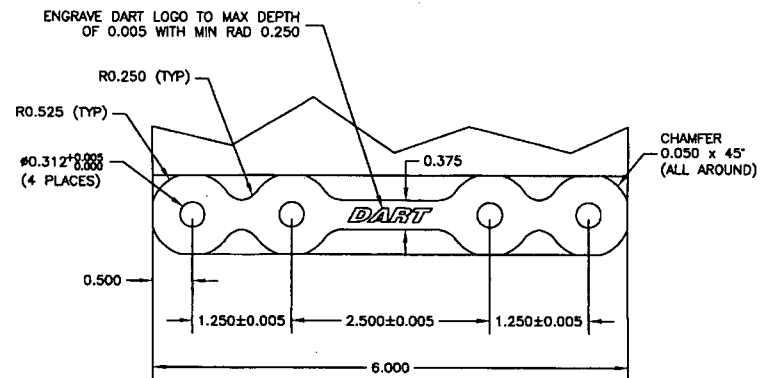
SHOOTING  
21 APR 1999

UNCLASSIFIED

NO. 42057  
2/10-9-15



SECTION A-A

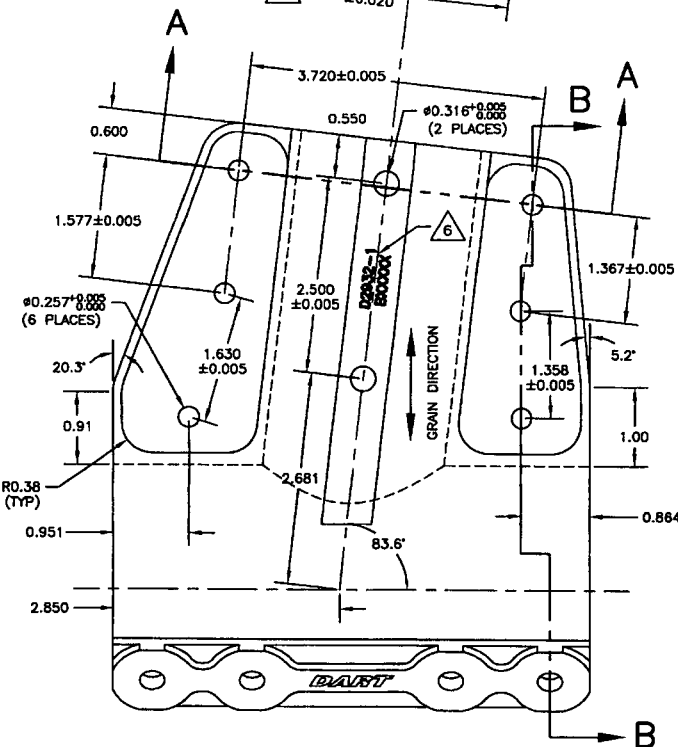


VIEW C-C

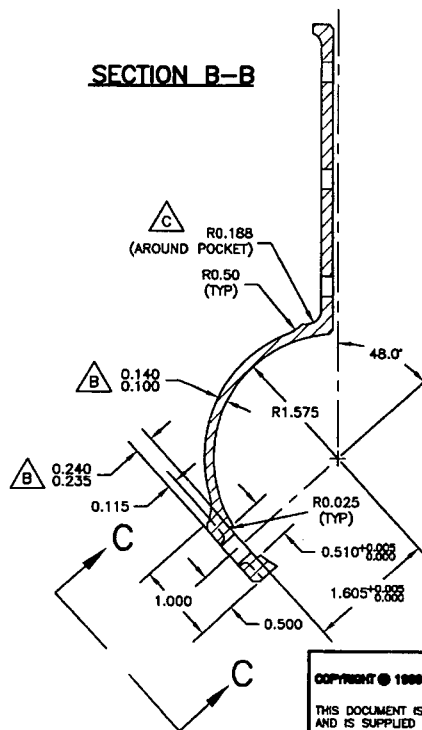
**D2932-1 LH SADDLE (SHOWN)**  
**D2932-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA	REV. C
CHECKED	APPROVED		
DATE	TITLE	D2932	SHEET 1 OF 1
06.11.09	SADDLE OUTSIDE		SCALE 2:3

RELEASED  
07-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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